

# Work Order ID 63217

Monday, October 25, 2010 12:35:37 PM



Page 1

Item ID: D212-725-1-107f

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*10-10-25*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2624 .040

1-Cut as per Dwg

Dwg Rev: F

Prog Rev: F

2-Deburr if necessary

*13 10-10-27*

*(4)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*13 10-10-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/10/127

(4)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 10/10/127

(4)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/128

(4)

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63217**

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Page 3

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Revision ID:

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Item Name: Angle

Start Date: 10/25/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

N PR 10-10-28

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/10/28

4 0

170

Identify as per dwg &amp; Stock Location: 386

0.00



Packaging

Memo

0.00

Packaging

Carpenter (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63217**

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Page 4

Item ID: D212-725-1-107f

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Setup Start



Revision ID:

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Item Name: Angle

Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 JF  
R/KO-10-28  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, October 25, 2010 12:35:41 PM

Work Order ID: 63217



Parent Item: D212-725-1-107f



Parent Item Name: Angle


Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	321.7400	0.09148	0.385179			



1810-10-27

Location

Loc Qty

Loc Code

MAT

84.2

114415

84.2

114415

MAT22

237.54

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

121.6

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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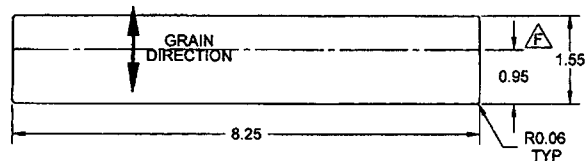
**NOTE:** Date & initial all entries

0212-725-1-1074

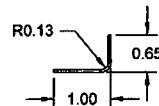
☒ **First Article**    ☐ **Prototype**

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-27	Date:	10/10/27	Date:	N/A

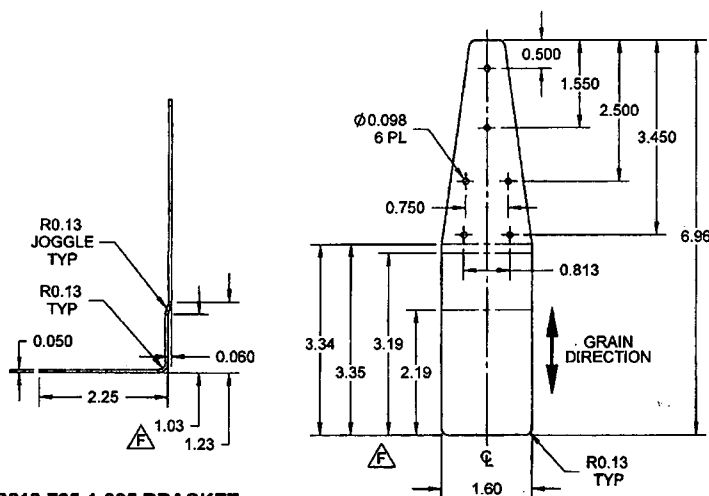
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D212-725-1-107F FLAT PATTERN**



**D212-725-1-107 ANGLE**  
(MAKE FROM D212-725-1-107F FLAT PATTERN)



**D212-725-1-085 BRACKET**  
(MAKE FROM D212-725-1-085F FLAT PATTERN)

**D212-725-1-085F FLAT PATTERN**

**D212-725-1-085 NOTE:**

1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.050)

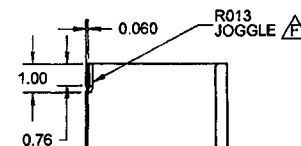
**D212-725-1-107 NOTE:**

2) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037  
(FER. DART SPEC. M2024T3S.040)



**GENERAL NOTES:**

- 3) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541, AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 4) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



GRAIN DIRECTION

R0.13 TYP

**D212-725-1-083F FLAT PATTERN**

**D212-725-1-083 SHELF SPLICE**  
**D212-725-1-084 OPPOSITE**  
(MAKE FROM D212-725-1-083F FLAT PATTERN)

**D212-725-1-083/084 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4  
(REF. DART SPEC. M2024T3S.050)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**RELEASED**  
09/06/01 JMB

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WORK ORDER  
NO. 63217

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		<b>D212-725-1</b>	SHEET 32 OF 84
APPROVED		TITLE	SCALE
DE APPR.		<b>212S DETAIL PARTS</b>	NTS
DATE	09.02.02	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

*10-10-25*

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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